

Work Order ID 77889

December-22-11 10:39:10 AM

77889

Page 1

Item ID: D4342-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step, RH Maintenance
 Start Date: 22/12/2011 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/22 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4342	A								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.00							
Large Fab	1-Cut D4342-1 using D2622 extrusion as per Dwg D4342 2-Drill, c'sink one hole on top of step as per dwg 3-Deburr and bevel ends for welding								
110	QC6- Inspect dimensions to drawing	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Weld per dwg A/R Aluminum rod Batch: <u>114514</u> Large Fab	0.00							
120									
Large Fab	Memo	0.00							
Large Fab	1-Weld end cap (ONE END ONLY) 2-Grind end cap welds flush 3-weld lugs as per Dwg D4342								

12-01-10 2 0

12-01-10 2 0
12-01-11

12-01-12 2 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2	0		
170 *170* Large Fab Large Fab	Weld per dwg A/R Aluminum rod Batch: <u>114514</u> Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remaining end cap as per Dwg D4342 3-Grind end cap weld flush as per dwg D4342 4- install rivert as per dwg	0.00 0.00				2	0		
180 *180* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				0			

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	QC5- Inspect part completeness to step on W/O	0.00							
190		0.00							
QC	Memo								
Quality Control									

200	Chemical Conversion Coat per QSI005 4.1	0.00							
200		0.00							
HandFinish	Memo								
Hand Finishing									

210	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
210		0.00							
Powdercoat	Memo								
Powder Coating									

MUA480

Start Time: 1:30
 Temp: 320°F
 Finish Time: 2:00

2X Ø M-L 12/01/16

W/O:		WORK ORDER CHANGES					
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
211	QC3- Inspect Part Finish	0.00							
211						2	BR	12-1-17.	
QC	Memo	0.00							
Quality Control									
215	Wing Walk as per dwg QSI005 4.4 Batch <u>120125</u>	0.00							
215						2	BR	12-1-17.	
HandFinish	Memo	0.00							
Hand Finishing									
220	QC3- Inspect Part Finish	0.00							
220						2 RH	φ	12/1/14	
QC	Memo	0.00							
Quality Control						count identified			

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location	0.00							
230									
Packaging	Memo	0.00							
Packaging									
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.00							
Quality Control									

(2x) SP 12-01-31

12/2/11

12-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

December-22-11 10:39:14 AM

Page 1

Work Order ID: 77889

77889

Parent Item: D4342-042

D4342-042

Parent Item Name: Step, RH Maintenance

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-12-22 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No				Each	106.0200		0.1			

D2622-120C

Step Extrusion

**

Ac 12.01.07

Location	Loc Qty	Loc Code
HALL	17.02	
46910	2	
64409	6	
66970	7.7	
68293	0.5	
<u>72131</u>	0.82	
WA013	89	
75781	89	

D2734

Manufactured No

Each 144.0000

2

D2734

Step End Plate

**

12.01.12

Location	Loc Qty	Loc Code
WA	135	
<u>76985</u>	135	
WA015	9	
73416	9	

D2734

Manufactured No

Each 144.0000

2

D2734

Step End Plate

**

12.01.14

Location	Loc Qty	Loc Code
WA	135	
<u>76985</u>	135	
WA015	9	
73416	9	

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 2

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Work Order ID: 77889

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Parent Item: D4342-042

D4342-042

Parent Item Name: Step, RH Maintenance

Start Date: 22/12/2011

Required Date: 05/01/2012

Start Qty: 2.00

Required Qty: 2.00

D3458-1 Manufactured No

Each 22.0000

2

D3458-1

Step Mounting Plate

**

12.01.12

Location

Loc Qty

Loc Code

WA002

21

75609

21

2

WA018

1

63075

1

2

D3458-3 Manufactured No

Each 32.0000

2

D3458-3

Step Mounting Plate

**

12.01.12

Location

Loc Qty

Loc Code

WA002

32

75610

32

2

MS20601-AD4W2 Purchased No

Each 176.0000

2

MS20601-AD4W2

Rivet

**

12.01.14

Location

Loc Qty

Loc Code

ST322

176

119232

176

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

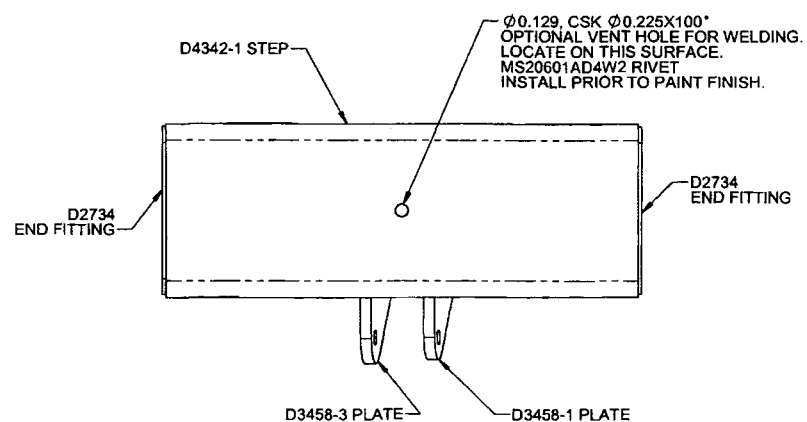
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

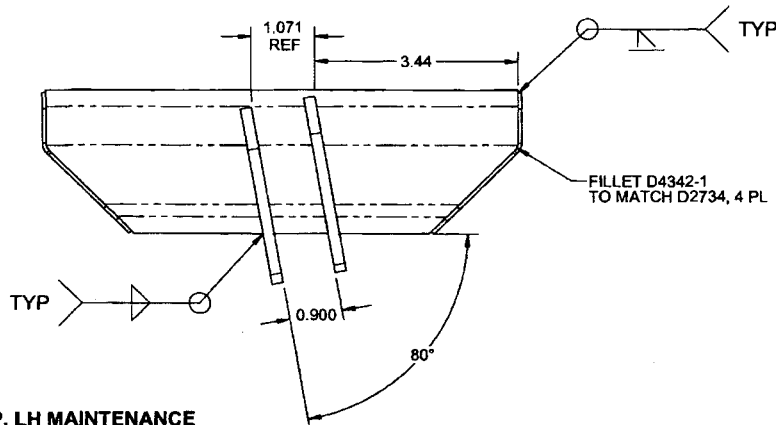
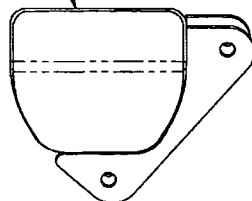
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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4342-041	STEP, LH MAINTENANCE
2	1	D4342-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4342-041 STEP, LH MAINTENANCE

SHOW COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77889 M.C.J
11/12/22

RELEASED
2011-05-24

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.65 lbs
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	CP	10.12.17
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4342** REV. A
SHEET 1 OF 3
TITLE **STEP, MAINTENANCE** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

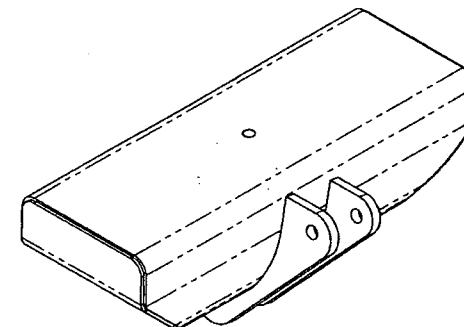
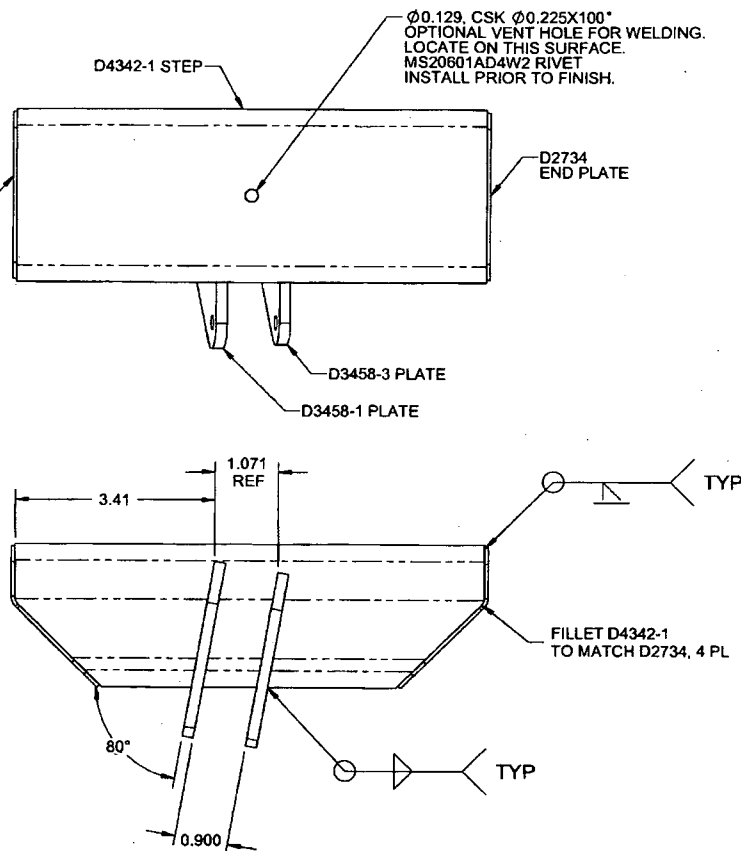
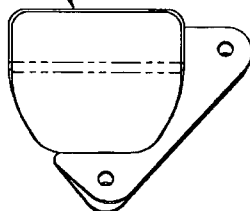
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ITEM	QTY	P/N	DESCRIPTION
1	X	D4342-042	STEP, RH MAINTENANCE
2	1	D4342-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)

2 APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D4342-042 STEP, RH MAINTENANCE

RELEASED
2011-05-26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N & B/N PER DART QSI 044 6.6 (REMOVABLE TAG)
- 7) WEIGHT: 0.65 lbs
- 8) WELDING: PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4342	REV. A
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		STEP, MAINTENANCE	SCALE
DE APPR.			NTS
DATE	10.12.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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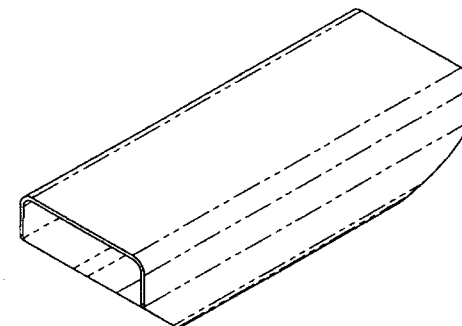
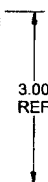
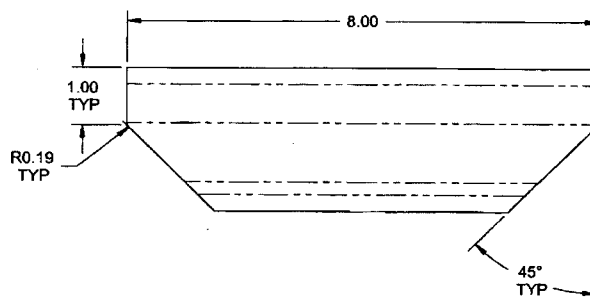
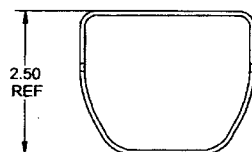
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NOTE: Date & initial all entries

77889



D4342-1 STEP

RELEASED
2011-05-24
WNI

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.52 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. A
MFG. APPR.		D4342	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, MAINTENANCE	NTS
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